

Work Order ID 67697

Tuesday, March 29, 2011 1:01:11 PM



Page 1

Item ID: D3303-041

Accept



Setup Start



Revision ID:

Item Name: Head Rest

Stop



Start Date: 3/29/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/1/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date: 11/29

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3303	Rev B

100



Small Fab

0.00

Small Fab

Memo

0.00

1- Bond foam to D3303-043 bracket assembly as per Dwg D3303 using 3M 1300/1300L adhesive. Identify as D3303-041 A/R 3M 1300/1300L Adhesive Batch: 1115230 2- Cover Head Rest with D3306-041 as per Dwg D3303

110



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

120



Packaging

0.00

Packaging

Memo

0.00

Identify with P/N and B/N, also identify the back of the headrest with TCCA-PDA # PDA04-11 using a permanent fine point marker as per Dwg D3303 , then Stock Location: 180

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3303-041

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

1/6/2011
MF
1-05-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 1

Tuesday, March 29, 2011 1:01:18 PM

Work Order ID: 67697



Parent Item: D3303-041



Parent Item Name: Head Rest

Start Date: 3/29/2011

Required Date: 4/1/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP: B04.10.05 Revised Step 5 with headIPP indentification KJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3303-043 		Manufactured	No			100	Each	0.0000	1	1		E 3/11/05/30	
Bracket Assembly						B41650	(1X)						
D3305-1 		Manufactured	No			100	Each	6.0000	1	1		E 3/11/05/30	
Cushion						ST180		6					
					66542			6					
D3306-041 		Manufactured	No			100	Each	7.0000	1	1		E 3/11/05/30	
Cover Assembly					ST184			1					
					40910			1					
				ST186				6					
				66545				6					

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

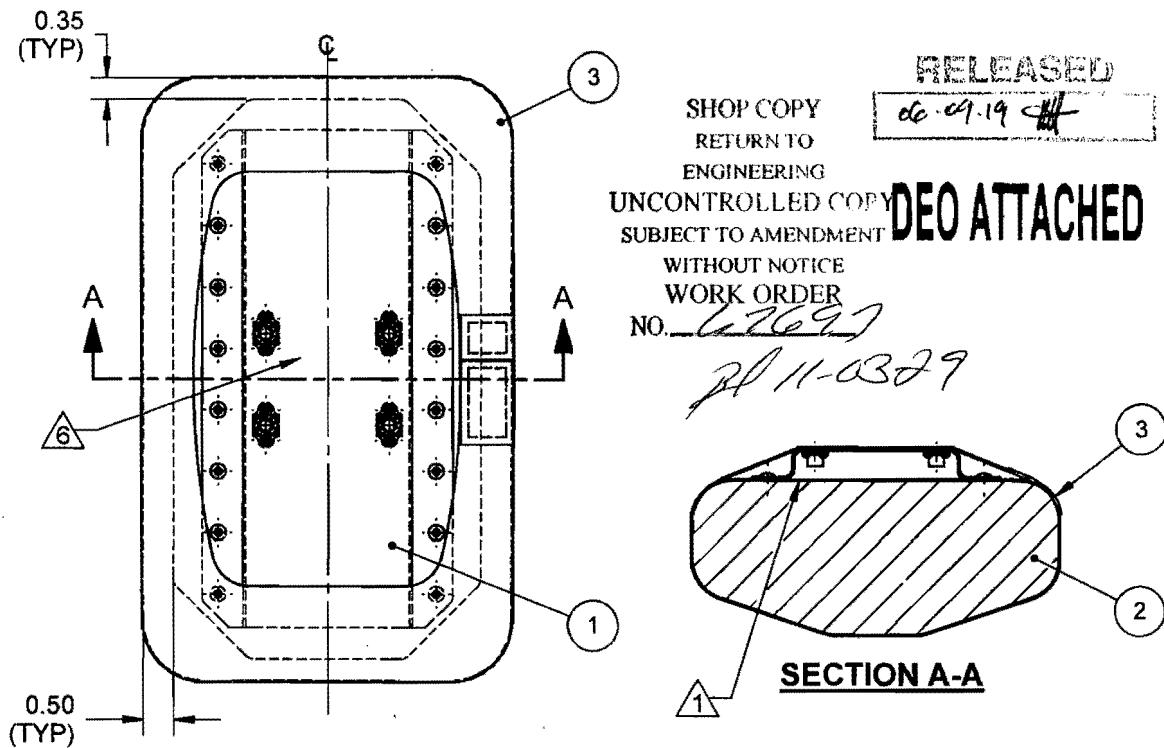
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>PF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PF</i>	DRAWING NO. D3303	REV. B	SHEET 1 OF 4
DATE 06.08.17		TITLE HEAD REST	SCALE	1:3
REV	DATE	DESCRIPTION		
A	04.08.18	NEW ISSUE		
B	06.08.17	UPDATED FLAT PATTERN TO FORM PART IN ONE OPERATION USING OFFSET DIE		

**D3303-041 HEAD REST**

ITEM	QTY -041	P/N	DESCRIPTION
	X	D3303-041	HEAD REST
1	1	D3303-043	BRACKET ASSEMBLY
2	1	D3305-1	FOAM
3	1	D3306-041	COVER ASSEMBLY

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS
- 2) COVER HEAD REST WITH D3306-041 COVER ASSEMBLY AS SHOWN
- 3) PART IS SYMMETRICAL AT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY AS FOLLOWS USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD, P/N D3303-041 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-11"

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

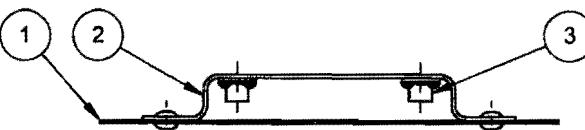
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>CF</i>	DRAWING NO. D3303
DATE 06.08.17	TITLE HEAD REST	REV. B SHEET 2 OF 4 SCALE 1:2

INSTALL ITEM ⑤
MS20470AD4-4 RIVETS
(16 PLACES)MASK THREADS
PRIOR TO PAINT
(4 PLACES)*w/o C1497*INSTALL ITEM ③
MS21075L3 NUT PLATE (1)
USING ITEM ④
MS20426AD3-3 RIVET (2)
(4 PLACES)**DEO ATTACHED****RELEASED***06.09.19***D3303-043 BRACKET ASSEMBLY**

ITEM	QTY -043	P/N	DESCRIPTION
	X	D3303-043	BRACKET ASSEMBLY
1	1	D3303-1	PLATE
2	1	D3303-3	HEAD REST
3	4	MS21075L3	NUT PLATE
4	8	MS20426AD3-3	RIVET
5	16	MS20470AD4-4	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

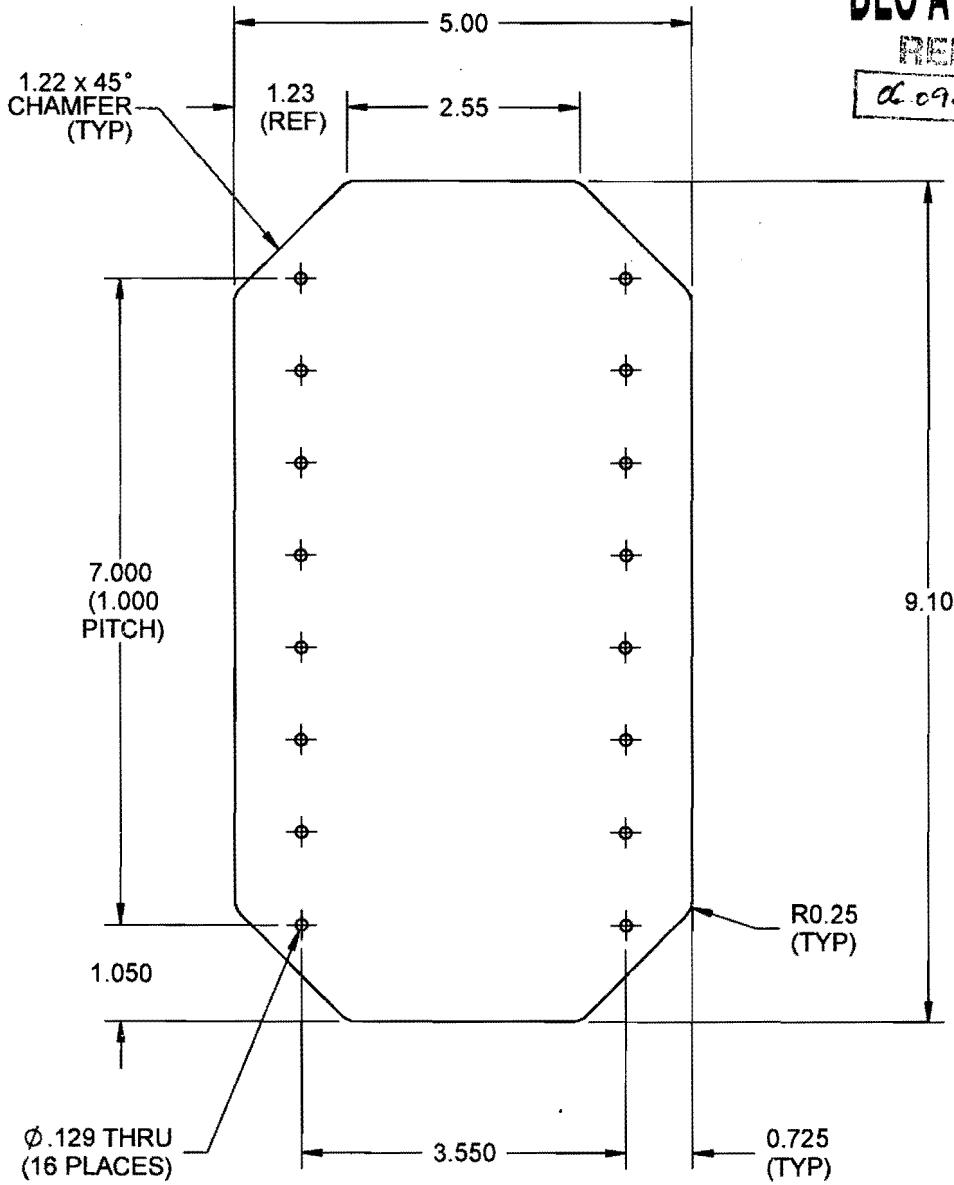
NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>JS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>JH</i>	DRAWING NO. D3303	REV. B SHEET 3 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2	

DEO ATTACHED

RELEASED

09.14 *M***D3303-1 PLATE****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.032 THICK SHEET
(REF. DART SPEC. M2024T3S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

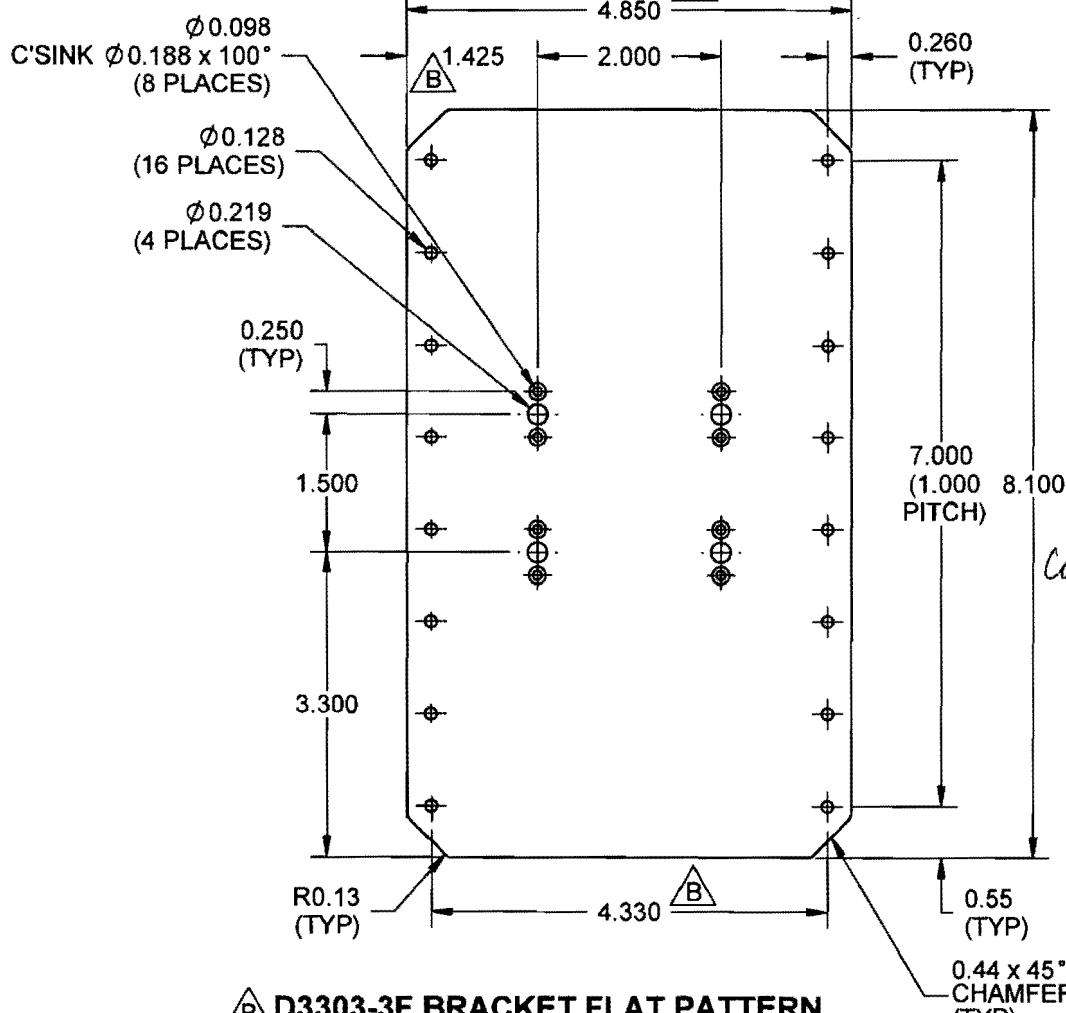
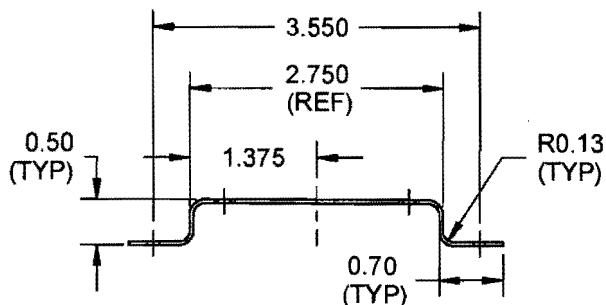
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>RF</i>	DRAWN BY <i>BS</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>SH</i>	DRAWING NO. D3303	REV. B	SHEET 4 OF 4
DATE 06.08.17	TITLE HEAD REST	SCALE 1:2		

DEO ATTACHED**D3303-3F BRACKET FLAT PATTERN****D3303-3 BRACKET BEND DETAIL****NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK SHEET (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT AS PER DART QSI 005.4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO.	TITLE	REV. B	DART AEROSPACE LTD ENGINEERING ORDER	D.E.O. NO.	SHEET NO.	SCALE
D3303	HEAD REST			D3303-B-1	SHEET 1 OF 1	NTS
DRAWN	AJS	CHECKED	MFG. APPR.	APPROVED	DE APPR.	
DATE 08.10.15	DATE 08.10.15		DATE 08/10/16	DATE 08/10/16	DATE 08/10/16	

SHEET 1 ADD 1300L ADHESIVE BY 3M TO NOTE 1 AS FOLLOWS:

u/o 67697

IS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 OR 1300L ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

WAS:

NOTES:

- 1) BOND D3305-1 FOAM TO D3303-043 BRACKET ASSEMBLY USING 3M 1300 ADHESIVE (0.002" TO 0.010" THICK) IN ACCORDANCE WITH MANUFACTURER'S INSTRUCTIONS

SEE NCR 08-069 FOR FURTHER DETAILS

RELEASED
08/11/16 JWD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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